

Date:
User:Friday, 06/02/2009 11:28:57 AM
Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 FLOOR PROTECTOR (CO-PILOT)
Job Number	: 45592		
Estimate Number	: 13787		
P.O. Number	:	Part Number	: D38741
This Issue	: 06/02/2009 S.O. No. :	Drawing Number	: D3874-1
Prsht Rev.	: NC	Project Number	: IN0002
First Issue	: 06/02/2009 Type : R&D THERMOFORMING	Drawing Revision	: PROTOTYPE 09.04.21 <i>PL</i>
Previous Run	:	Material	: To Be Determined
Written By	:	Due Date	: 16/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <i>JUD 09.02.06</i>		
Comment	: Est. Rev A 09.02.06 New Issue DL		

Additional Product

PROTOTYPE
ENGINEERING
APPROVAL

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MLEXANG425 - MLEXS 118 90318 08 1/8" Lexan Sheet



M110566.



P10 →

Comment: Qty.: 8.0000 sf(s)/Unit Total : 16.0000 sf(s)
1/8" Lexan Sheet 8.365 Total *8.365*

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

09/02/06 *DL*

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

09/02/06 *DL*

4.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3874-1 and folio (FTA 38742 Prototype) using tool DT 9453

Dwg. Rev. PROTOTYPE
Folio Rev. A

09/02/06 *DL*

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

09/02/06 *DL*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.04.06	1	MATERIAL 1118 TEXTURED LEXAN. SAMPLE Supplied by Sabic. Do NOT DRAW MAT FROM STOCK.					

Mat'l
cert
attached
Pg 09.04.06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/02/2009 11:28:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 FLOOR PROTECTOR (CO-PILOT)

Job Number: 45592

Part Number: D38741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09/02/09 (X2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

(X2)

1) Trim to Finished Dimensions

09/02/09 W.

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/09 (X2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090416 (P)

F.d as prototypes.

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eng's } AU 090421
testing }

FOR ENGINEERING USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

090422

Prototype only

Job Completion



U 09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

45592 ¹² 09.04.22

DART AEROSPACE LTD		Work Order: 45593
Description: 206 FLOOR PROTECTOR PLOT		Part Number: D3874-1
Inspection Dwg: D3874	Rev: A.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/04/16.

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.8		21.9	✓			
19.2		19.6	✓			
2.3		2.5	✓			
.5	MIN	.625	✓			
0.050	MIN		✓			
0.075	MIN		✓			

09.04.20

Measured by: BB

Date: 09/04/16.

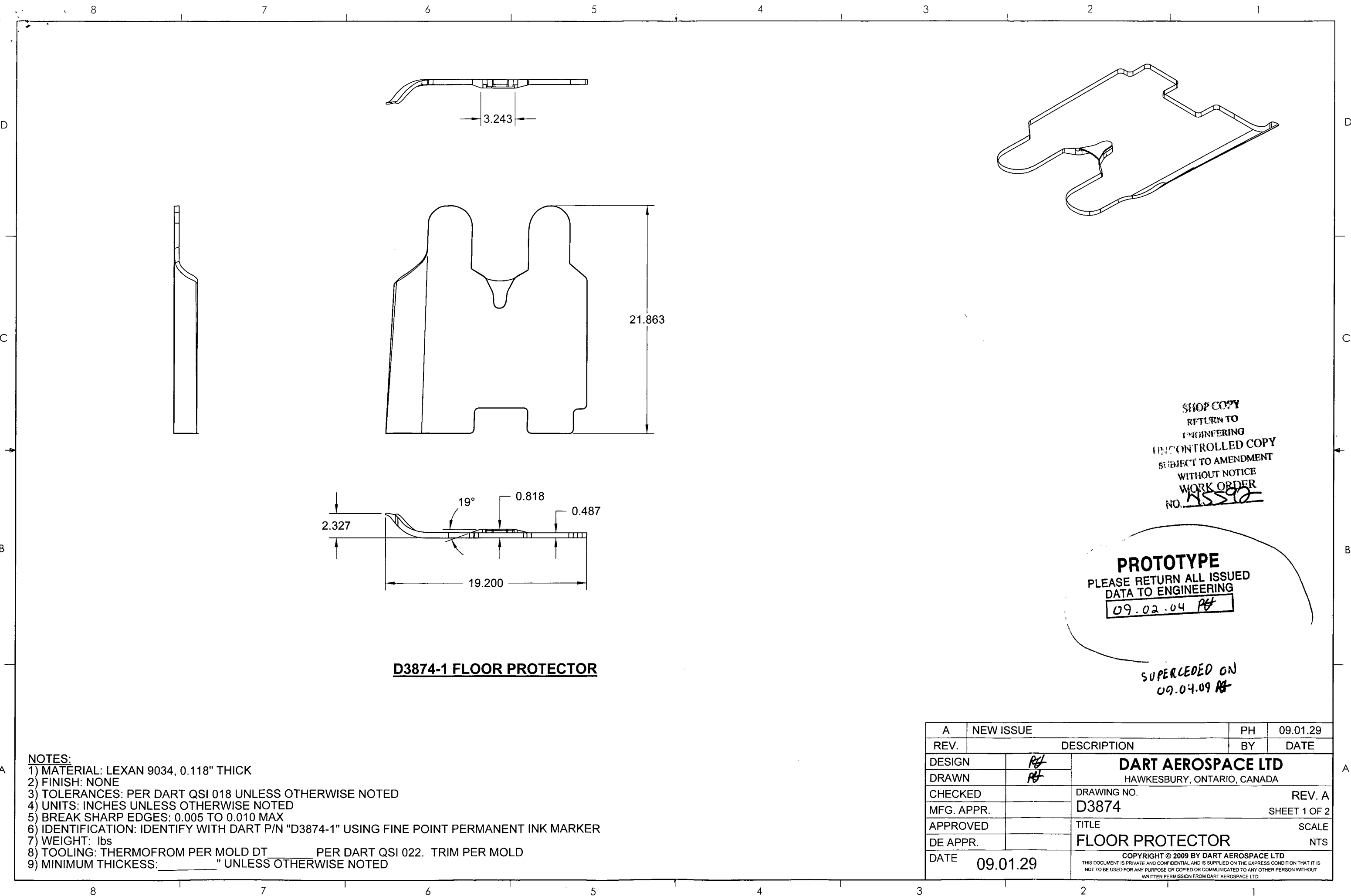
Audited by: 2

Date: 09.04.16

Prototype Approval: PH

Date: 09.04.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



NOTES:

- 1) MATERIAL: LEXAN 9034, 0.118" THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: lbs
- 8) TOOLING: THERMOFROM PER MOLD DT _____ PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: _____" UNLESS OTHERWISE NOTED

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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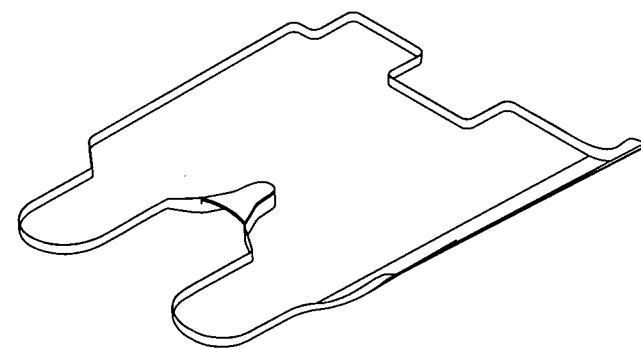
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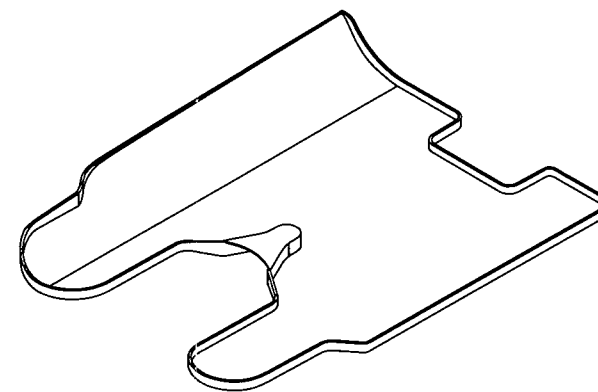
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D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.09 *PH*

SUPERCEDED
ON
09.04.22 *PH*

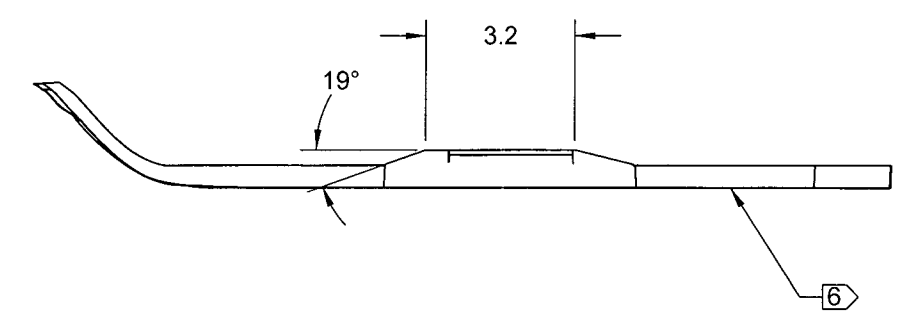
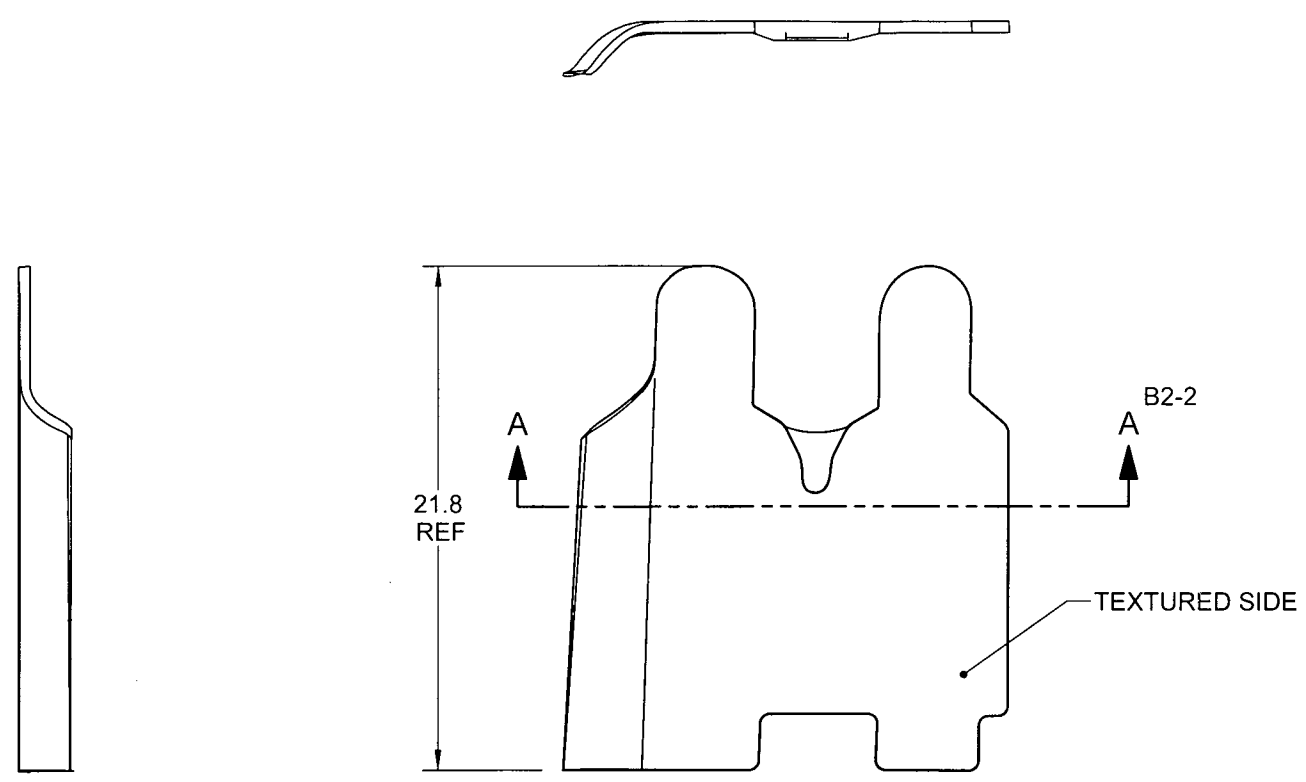
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MFG. APPR.		D3874	SHEET 1 OF 3	
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SECTION A-A
SCALE 2X

D3874-1 FLOOR PROTECTOR

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.09 *PH*
SUPERCEDED
ON 09.04.09 *PH*
22

- NOTES:
- 1) MATERIAL: LEXAN 90318, 0.118 THICK, 112-CLEAR
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.5 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.085" ELSEWHERE

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CHECKED		DRAWING NO.	REV. A
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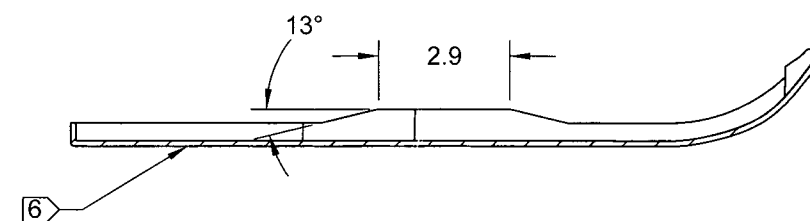
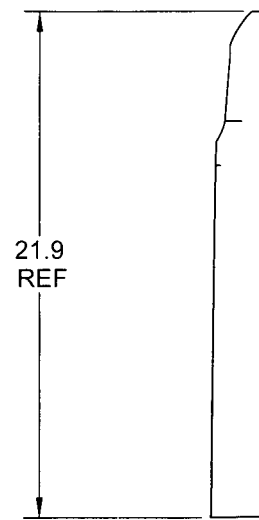
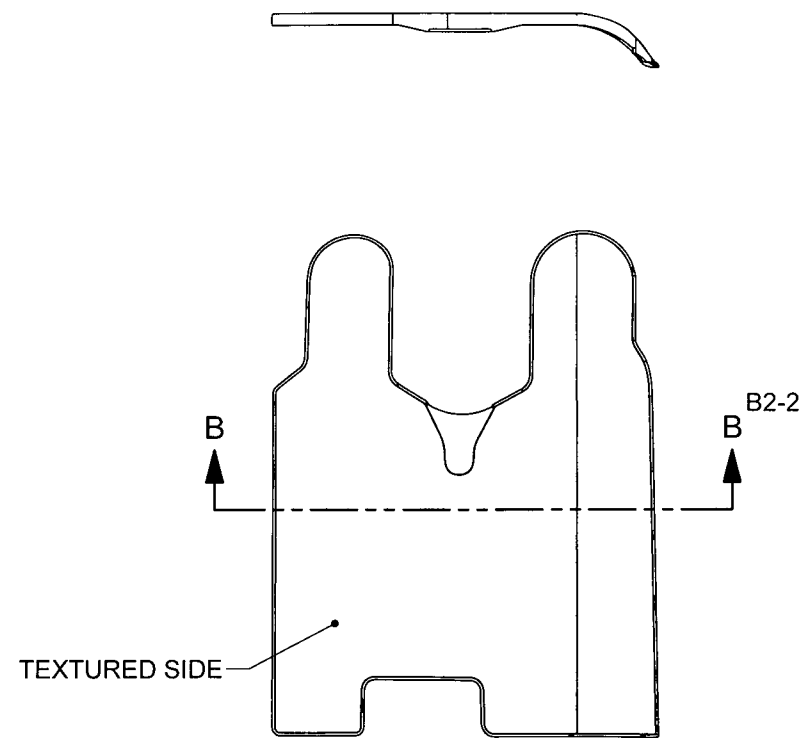
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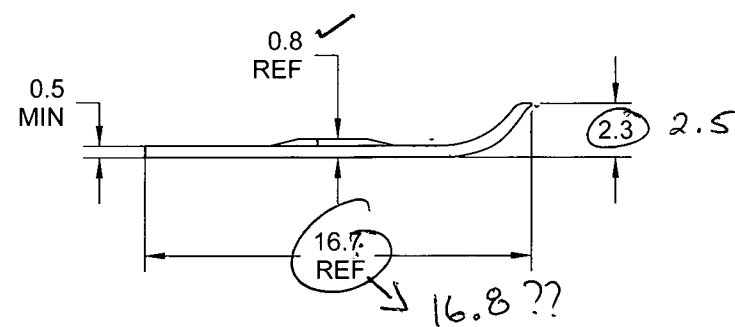
C

B

A



SECTION B-B
SCALE 2X



D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318, 0.118 THICK, 112-CLEAR
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.04.09 *RA*
09.04.22 *RA*

DESIGN	<i>RA</i>	DART AEROSPACE LTD	
DRAWN	<i>RA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 3 OF 3
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SABIC Polymershapes

سابك
sabic

INVOICE NO.	0085310/M
INVOICE DATE	21.01.09
TAKEN BY	melkertd
G.S.T. REG. NO.	856372750RT0001
CARRIER	

INVOICE

SOLD TO: DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
Canada

SHIP TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
ATTN: LINDA LACELLE
HAWKESBURY ON K6A 1K7
Canada

PST 85637 2750 TR000

A/C 22.3

CUSTOMER DARAER	SHIP VIA EPIC	TAX LIC 1 CHARGE GST	TAX LIC 2 6112-5207	INVOICE TERMS NET 30 DAYS	SALES ORDER PAGE O85498 1	WHS. 99
CUSTOMER P.O. SAMPLE	SHIP DATE 21.01.09	FREIGHT TERMS PREPAID	SALES REP. WADE DIXON	S.D.N. 01	BILL OF LADING	Sch. Date 21.01.09
						Sales Office 99

LN	PRODUCT	ORDER	B/O	SHIP	SKU	DESCRIPTION	PRICE	PER	EXTENSION
001	11201655	1	0	1	SHT	*** SAMPLE REQUEST *** 90318-112 PROTECT A GLAZE .118 X 60 X 96	1	.00	SHT 0.00
002	0000005	1	0	1	EA	THANK YOU FOR SELECTING SABIC POLYMERSHAPES GST PAYABLE @ 5%	1	.00	EA 0.00
						PLEASE PAY THIS AMOUNT			0.00
						=====			
						Balance Outstanding			0.00
						**** PAID ****			
						RECEIVED JAN 27 2009			

						*** IF YOU ARE NOT CURRENTLY RECEIVING OUR INVOICES ***			
						*** VIA EMAIL OR FAX, PLEASE SUPPLY US WITH AN EMAIL ***			
						*** ADDRESS OR FAX NUMBER . FAX TO 905-789-3161 ***			

						*			

PLEASE Remit To: SABIC Polymershapes 9150 Airport Road Brampton ON L6S 6G1

Phn : (613)745-7043 Fax : (613)745-4291

NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

Receiving Report

Date: 09/10/12

Batch No: 110566

Supplier: Sabic Poly.

Dart P/O: ~~7702~~ SAMPLE

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☐
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☐ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☐ N/A ☐
 Shipment Complete: Yes ☐ No ☐ N/A ☐
 QCS Inspection ☐ N/A ☐
 Work Order ☐ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	<u>Sample</u>	<u>1</u>	<u>1</u>			

Initials of receiver (if shipment OK) Level 12 CX

Production/Admin:

Date

Received/Costing

Initial

Location

H:\FORMS\Purchasing\approved purch\RECREPORT.R v D

THANK YOU FOR SUBMITTING
 SHIPMENT POLYMERIZATION

[Faint, mostly illegible text and markings in the lower section of the form, including what appears to be a signature and date.]

DISCREPANCIES MUST BE REPORTED WITHIN 10 DAYS.
 UNLESS INDICATED OTHERWISE, ALL PACKAGES

SABIC
Innovative
Plastics™

سابك
sabic

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: Jan. 21, 2009

YOUR PURCHASE ORDER: N/A

OUR SHIPPER NO: 085498

INVOICE NO: 0085310

SABIC POLYMERSHAPES LINE ITEM # 001

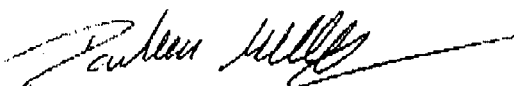
QUANTITY: 1 SAMPLE SHEET

DESCRIPTION: 90318-112 - PROTECT A GLAZE - .118 X 60 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: UL-94-HB

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

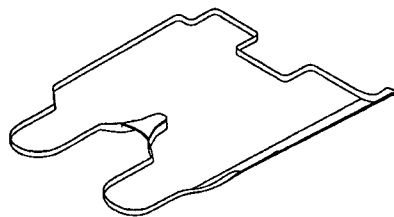


DARLEEN MELKERT
INSIDE SALES REPRESENTATIVE

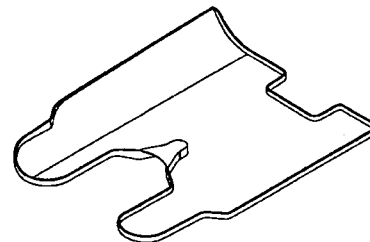
1450 Old Times Road
Unit 519
Ottawa, Ontario
K1B 5L3

T: 613-745-7043
F: 613-745-4291
E: darleen.melkert@sabic-ip.com
www.sabic-ip.com

M110566



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

SUPERCEDED ON
09.04.22 *PH*

PROTOTYPE
09.04.24 *RB*

A		NEW ISSUE		PH		09.01.29		
REV.		DESCRIPTION				BY DATE		
DESIGN		PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN		PH						
CHECKED				DRAWING NO.		REV. A		
MFG. APPR.				D3874		SHEET 1 OF 3		
APPROVED				TITLE		SCALE		
DE APPR.				FLOOR PROTECTOR				NTS
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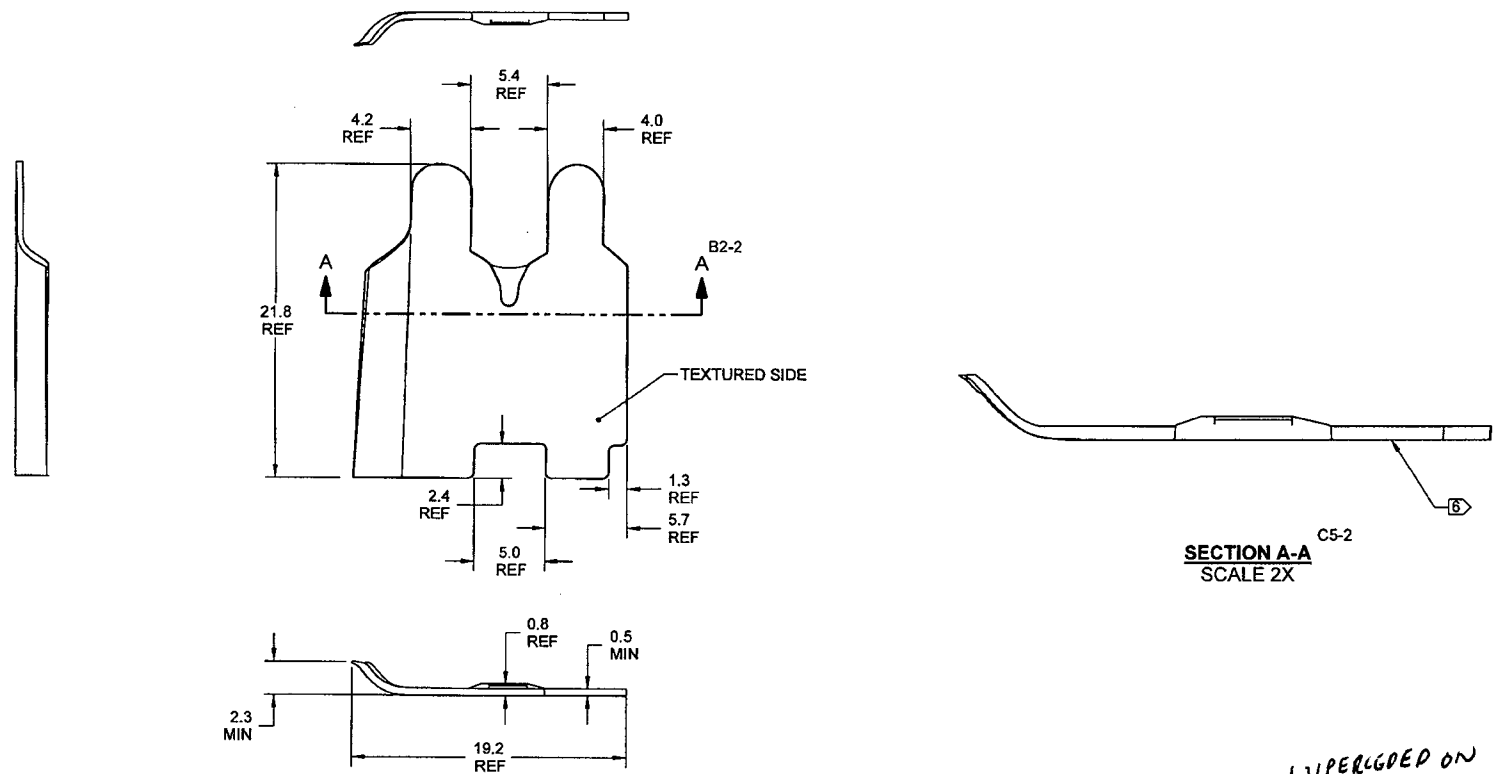
A

D

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B

A



D3874-1 FLOOR PROTECTOR

SECTION A-A
SCALE 2X

SUPERSEDED ON
09.04.22 PH

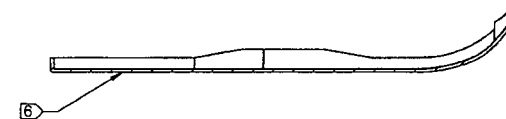
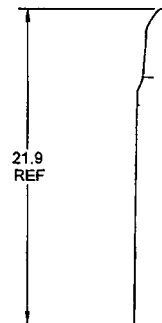
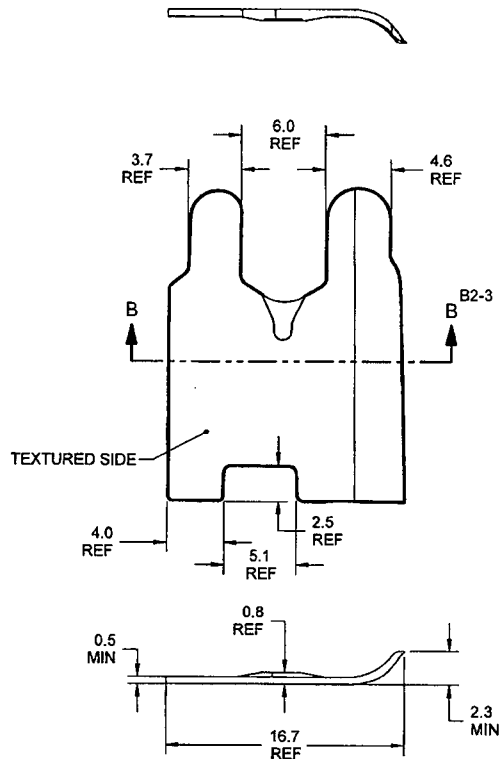
PROTOTYPE
09.04.21 PH

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE

SUPERCEDED ON
09.04.22 PAX

PROTOTYPE
09.04.21 PAX

DESIGN	PH	DART-AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3874	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	FLOOR PROTECTOR	NTS
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